

Date: Friday, 12/21/2007 7:27:38 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 36518					
Estimate Number	: 10346					
P.O. Number	: N/A		Part Number	: D2596		
This Issue	: 12/21/2007	S.O. No.	N/A	Drawing Number	: D2596 REV D	
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: 36328		Material	: N/A		
Written By			Due Date	: 1/20/2008		
Checked & Approved By			Qty:	4 Um: Each		
Comment	: Est: D 99-02-02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - 'I' Beam Web 4"	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion 33940 SL 8-1-8			
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 8-1-8

6.0 QC21 FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008 11/18

108/01/09

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

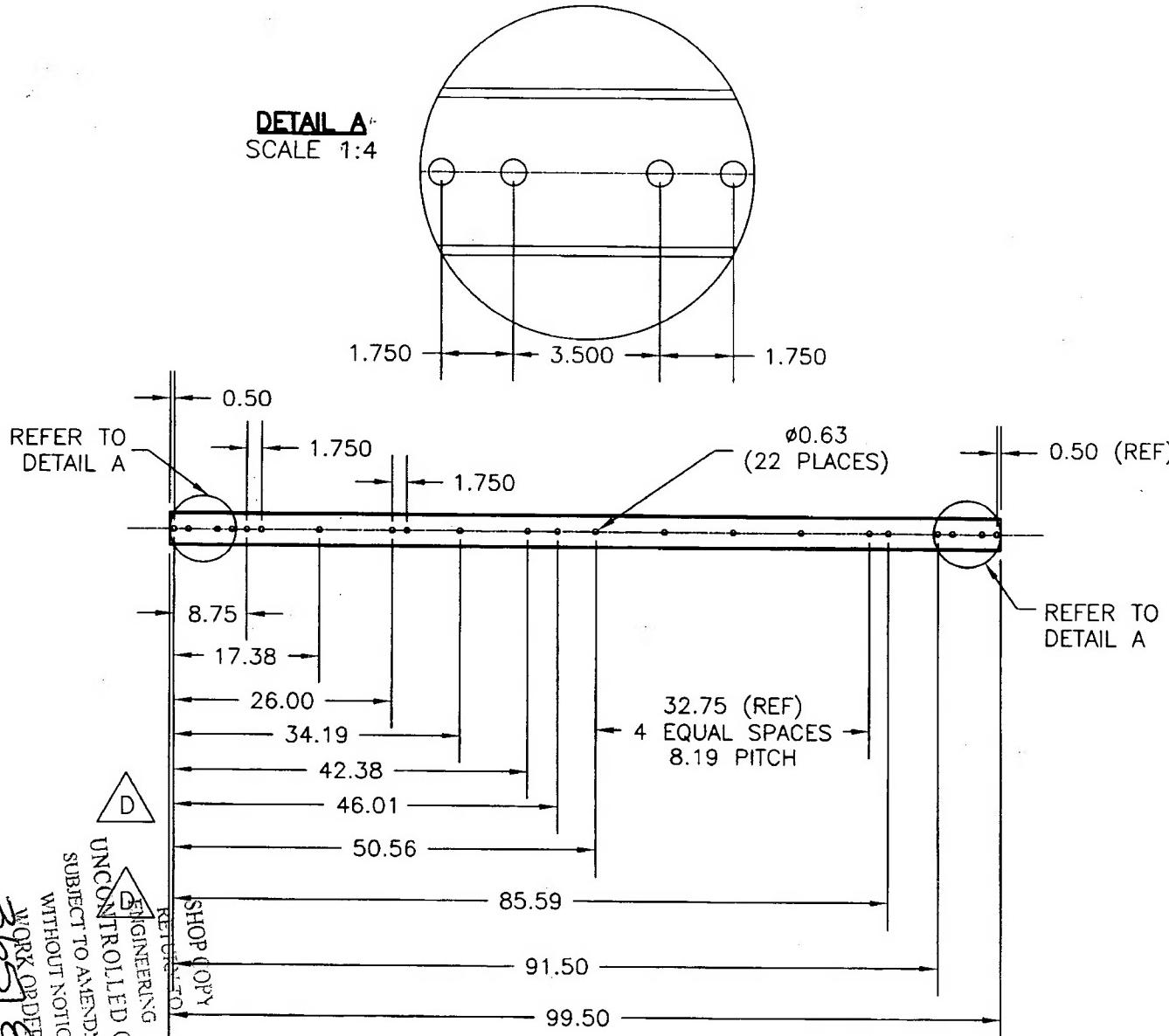
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART**RELEASED**

R 07.06.18

DESIGN <i>R4</i>	DRAWN BY <i>BH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	SHEET 1 OF 1	REV. D
DATE 07.04.17		TITLE 205 WEB		SCALE 1-20
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

WORK ORDER
NO. 36518**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020